

# Work Order ID 63299

Wednesday, October 27, 2010 10:50:36 AM



Page 1

Item ID: D212-725-1-063F

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 10/27/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *M*

Date: *10-10-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N): *h*

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-1	B

100

0.00



Waterjet

Memo

0.00

*B10-10-28*

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

*2024 .050*

*(4)*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

*B10-10-28*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63299**

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Page 2

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Start Date: 10/27/2010 Start Qty: 4.00

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Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 63299**

Wednesday, October 27, 2010 10:50:36 AM

Page 3

Item ID: D212-725-1-063F

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Revision ID:

Item Name: Stiffener

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/30/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

170



Packaging

Packaging

Identify as per dwg & Stock Location: 383

0.00

0.00

Memo



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63299**

Wednesday, October 27, 2010 10:50:36 AM

Page 4

Item ID: D212-725-1-063F

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Setup Start

Revision ID:

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Item Name: Stiffener

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.10.29

K 10-10-29  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, October 27, 2010 10:50:40 AM

Page 1

Work Order ID: 63299



Parent Item: D212-725-1-063F



Parent Item Name: Stiffener

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	103.8847	0.0855	0.36			



2024-T3 .050 sheet



10-10-28

Location

Loc Qty

Loc Code

MAT22

103.8847

111381

11.89

113189

0.3947

114968

91.6

114968

(4)

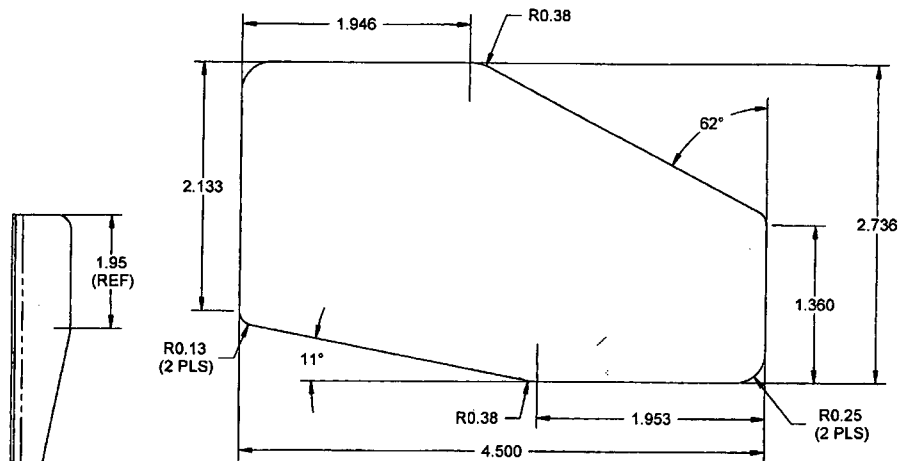
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

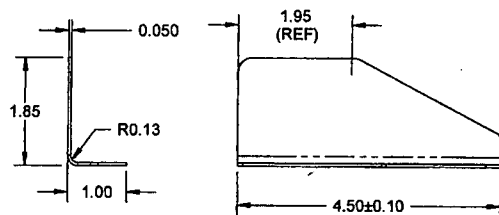
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D212-725-1-063F FLAT PATTERN**

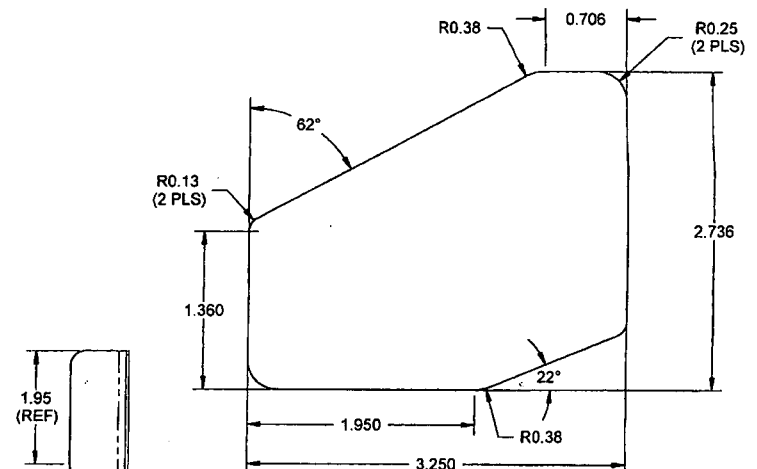


**D212-725-1-063 STIFFENER, LH SHOWN**  
**D212-725-1-064 STIFFENER, RH OPPOSITE**  
 (MAKE FROM D212-725-1-063F FLAT PATTERN)  
 SCALE 1:2

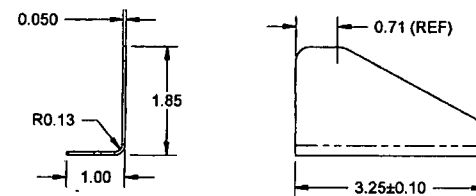
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. *63299*  
*P/10-10-27*

**NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



**D212-725-1-065F FLAT PATTERN**



**D212-725-1-065 STIFFENER, LH SHOWN**  
**D212-725-1-066 STIFFENER, RH OPPOSITE**  
 (MAKE FROM D212-725-1-065F FLAT PATTERN)  
 SCALE 1:2

**RELEASED**  
 2009-10-28

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D212-725-1</b>
DATE <b>07.05.11</b>	TITLE <b>212S DETAIL PARTS</b>	REV. B SHEET 26 OF 44 SCALE 1:1
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DD12-725-1-063F

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-28	Date:	10/10/28	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD